

Appl. No. 09/869,532
Amdt. dated Aug. 13, 2003
Reply to Office action of Feb. 13, 2003

Amendments to the Claims:

This listing of claims will replace all prior versions, and listings, of claims in the application:

Listing of Claims:

Claim 1 (currently amended): A method for manufacturing products with a coating, wherein from at least one mass comprising at least natural polymers, a base product is manufactured, having a first coating upon one relevant part thereof, and a second coating over at least a portion of said first coating, ~~said first coating, while to at least one part of the product, a coating is applied, a coating being used~~ having a surface tension which is approximately equal to or preferably lower than the surface tension of a portion of the at least one portion of the base product mass, ~~of the or each relevant part of the base product to which the coating is applied, characterized in that to at least a , a first coating is applied, after which a second coating is applied over at least a portion of the first coating, such that at least part of the product is covered by the first and second coating and a further part of said product is covered by the first or second coating only.~~

Claim 2 (original): A method according to claim 1, wherein the base product is formed in a mold with raising of pressure and/or temperature, preferably by means of injection molding.

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Claim 3 (original): A method according to claim 1, wherein the at least one mass is introduced in or through a mold and is heated in the mold, such that at least cross-linkage of the natural polymers occurs, while surface tension-reducing agents are incorporated in the mass.

Claim 4 (original): A method according to claim 1, wherein the at least one mass is at least substantially manufactured as paper-forming mass.

Claim 5 (original): A method for manufacturing coated products, according to claim 1, wherein in the at least one mass, release agents are incorporated in an amount such that during heating, a portion of the release agents egresses from the mass and bonds to the wall of the mold, such that during manufacture of successive products in the same mold, a substantial constant layer of release agent always remains present.

Claim 6 (original): A method according to claim 1, wherein as release agent, a surface tension-reducing component is added to the mass.

Claim 7 (currently amended): A method according to claim 1, wherein a coating is used having a surface tension of less than 42 dyne/cm (~~42*~~42 $\times 10^{-3}$ N/m), preferably less than 36 dyne/cm (~~36*~~36 $\times 10^{-3}$ N/m) and more in particular less than 32 dyne/cm (~~32*~~32 $\times 10^{-3}$ N/m).

Claim 8 (original): A method according to claim 1, wherein a product is formed which, after leaving the molding die in which it is formed, has a surface tension of less than 44

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dyne/cm and greater than 30 dyne/cm, while a coating is applied to at least a portion of the surface, said coating being water based and having a surface tension of between 40 and 27 dyne/cm.

Claim 9 (original): A method according to claim 1, wherein the product, upon leaving the mold, has a moisture content of less than 3 wt. %, while by means of coating, moisture, in particular water, is introduced into the product.

Claim 9 (original): A method according to claim 1, wherein the product, upon leaving the mold, has a moisture content of less than 3 wt.%, while by means of coating, moisture, in particular water, is introduced into the product.

Claim 10 (original): A method according to claim 1, wherein as coating, a water based, one phase system is used, preferably having few micelles.

Claim 11 (currently amended): A method according to claim 1, wherein the at least one coating is applied to the base product at a temperature of between 20°C and 50°C, preferably between 25°C and 50°C, the arrangement being such that the surface tension of the coating is slightly reduced with respect to the surface tension at lower-temperature temperatures.

Claim 12 (currently amended): A method according to claim 1, wherein as coating, in particular as first coating, a coating is used comprising at least one component from the group consisting of+ melamine, acrylic binders, water-resistant lacquers, cellulose lacquers, cellulose

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acetate propionates, polyethylene, polyacrylates, synthetic polymers, natural polymers, synthetic waxes, natural waxes, polyactic acid, ~~derivatives of the preceding or and combinations of the preceding thereof.~~

Claim 13 (currently amended): A method according to claim 1, wherein as coating, in particular as second coating, a coating is used comprising at least one component from the group consisting of: acrylic binders, latices, styrene-butadiene latex, polyvinyl alcohol, polyvinyl acetate, polyacrylates, polyethylene glycol, polyactic acid, synthetic polymers, natural polymers, natural waxes, synthetic waxes, for instance ionic polyethylene waxes, and derivatives of the preceding or combinations of the preceding thereof.

Claim 14 (original): A method according to claim 1, wherein in the coating, in particular the first and/or second coating, cross linkers are incorporated.

Claim 15 (currently amended): A method ~~according to~~ in accordance with claim 14, wherein the cross-linking agent is selected ~~cross-linkers are used~~ from the group consisting of zirconium acetate, urea formaldehyde, melamine formaldehyde, glyoxal, ammonium zirconium carbonate, polyamideamine-epichlorohydrin, epoxides, trimetaphosphate ~~derivatives thereof or and combinations of the preceding thereof.~~

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Claim 16 (original): A method according to claim 13, wherein in the at least one coating, at least one of the waxes is combined with at least one of the other components mentioned.

Claim 17 (original): A method according to claim 1, wherein at least one coating is used which increases the water vapor proofness of the product.

Claim 18 (original): A method according to claim 1, wherein at least as outer or outermost coating, and FDA-allowed coating is used.

Claim 19 (original): A method according to claim 11, wherein at least as outer or outermost coating, a fat-resistant and/or fat-tight coating is used.

Claim 20 (currently amended): A method according to claim 1, wherein the at least one coating is applied to only one part of the product, the surface tension of the parts of the product that remain clear of the coating being kept or rendered ~~relatively low with respect to~~ lower than the surface tension of said coating.

Claim 21 (original): A method according to claim 1, wherein the product is manufactured from at least two different masses, the surface tensions of the parts formed from the different masses preferably differing from one another.

Claim 22 (original): A method according to claim 1, wherein the at least one coating is applied by spraying.

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Claim 23 (original): A method according to claim 1, wherein the at least one coating is applied by atomizing.

Claim 24 (original): A method according to claim 22, wherein the at least one coating is applied by airless spraying or atomizing.

Claim 25 (original): A method according to claim 22, wherein the at least one coating is applied by spraying or atomizing with compressed air-control.

Claim 26 (original): A method according to claim 1, wherein the product has at least one receiving cavity, the receiving cavity being at least partially filled with fluid coating and subsequently poured empty, such that a film of coating remains behind on at least a portion of the wall of the receiving cavity.

Claim 27 (original): A method according to claim 1, wherein on or in at least a part of the base product there is provided an agent influencing the properties of the relevant product part, prior to the application of the at least one coating to the relevant product part.

Claim 28 (original): A method according to claim 27, wherein as said influencing agent, a softener or softener-containing gent is used.

Claim 29 (original): A method according to claim 27, wherein as said influencing agent, water or a water-containing agent is used.

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Claim 30 (original): A method according to claim 1, wherein a coating is used comprising an agent influencing the properties of the base product, in the form of at least a softener.

Claim 31 (original): A method according to claim 30, wherein as softener, water is used.

Claim 32 (currently amended): A method according to claim 30, wherein to the relevant base product part, at least one coating is applied which is denser than relatively dense ~~with respect to~~ said agent influencing the properties of the base product.

Claim 33 (currently amended): A method according to claim 1, wherein a coating is used in which a surface tension-reducing agent is included which provides for a reduction of the surface tension of the coating layer after drying.

Claim 34 (original): A method according to claim 33, wherein as surface tension-reducing agent, an oily or oil-containing product is used.

Claim 35 (original): A method according to claim 33, wherein as surface tension-reducing agent, silicone oil is used.

Claim 36 (currently amended): A method according to claim 35, wherein between 0.5 and 15 ~~vol.-%~~ of silicone oil based upon the total volume of coating composition together with silicone oil is employed-used.

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Claim 37 (currently amended): A method according to claim 36, wherein between 2 and 10 ~~vol-%~~ of silicone oil based upon the total volume of coating composition together with silicone oil is employed~~is used~~.

Claims 38-47 (canceled)